

Monday, July 25, 2016 2:26:42 PM

149523

Page 1

Item ID: D3183-044

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket Assembly

Stop *NS2*

Start Date: 7/11/2016 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: AUG 02 2016

Date: 21

Tooling:

Date: _____

Run Start *NR1*

QC: _____ Date: _____ 9-89

Date: 9-89

SPC (Y/N):

Date: _____

Stop *NR2*

100		0.00				
100	BAND SAW					
Bandsaw						
	Memo	0.03				
Jeaspa Bandsaw	Cut blanks: (1.500" x 2.250") 5.500" long					

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

0.67

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine D3183-4 as per Folio FA322 and Dwg D3183

Identify as D3183-4

2-Debut

3-Scribe batch number

DAS
45
9-89
2016-10-05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 149523

Monday, July 25, 2016 2:26:42 PM

149523

Page 2

Item ID: D3183-044

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket Assembly

Start Date: 7/11/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120						4	0		
QC	Memo	0.01							
Quality Control									2016-11-08
130	QC8- Inspect parts - second check	0.00							
130						4	0		
QC	Memo	0.01							
Quality Control									DAS 14 9.89 16/10/12
140	Small Fab	0.00							
140						4x			
Small Fab	Memo	0.02							
Small Fab	Assemble D3183-044 as per Dwg D3183.								16/10/11 DAS 36 9.89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By _____		
							Lead hand / Supervisor Approval Verification _____		
							QC / QA Coordinator Approval _____		

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : _____			

Work Order ID 149523

Monday, July 25, 2016 2:26:42 PM

149523

Page 3

Item ID: D3183-044 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket Assembly
Start Date: 7/11/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/25/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				<u>4</u>			DAS 38 9-89 OCT 20 2016
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>St021</u> Memo	0.00 0.01				<u>4</u>	OCT 21 2016		DAS 6 9-89
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							DAS 21 9-89 OCT 21 2016 VS 16/10/21 DAS 21 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
240 300 1000				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, July 25, 2016 2:26:42 PM

Page 1

Work Order ID: 149523

149523

Parent Item: D3183-044

D3183-044

Parent Item Name: Bracket Assembly

Start Date: 7/11/2016

Required Date: 7/25/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:Pick:A04.02.18New issueKJ/DS
IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3121-21		Manufactured	No			140	Each	2.0000	2	8			
D3121-21									**			16/10/19	DAS 36 9-89
Bolt													

Location	Loc Qty	Loc Code
----------	---------	----------

ST018	2	
145436	2	

D3183-045		Manufactured	No			100	Each	31.0000	2	8			
D3183-045									**			16/10/19	DAS 36 9-89
Bearing Assembly													

Location	Loc Qty	Loc Code
----------	---------	----------

FG	4	
139821	2	
141815	2	
ST021	27	
148004	7	
148738	20	

M174B1.500X02.250		Purchased	No			140	f	6.3100	0.4583	1.929684			
M174B1 500X02 250									**				
17-4 SS Bar 1.50 X2.250													

Location	Loc Qty	Loc Code
----------	---------	----------

MAT010	6.31	
m133511	6.31	

m135690

1.929684 ¹⁴ DAS 45 2016-10-05 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____						

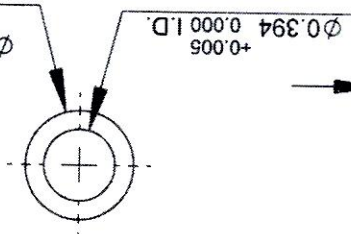
DART AEROSPACE LTD		Work Order:	149523
Description: Bracket		Part Number:	D3183-4
Inspection Dwg: D3183	Rev: C1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

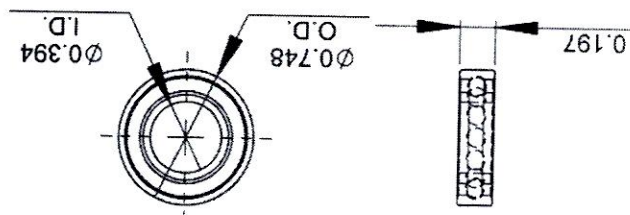
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R.188	/			
R0.063	+/-0.010	R.063	/			
0.182	+/-0.010	-182	/		VERU	SL-40
0.070	+/-0.010	-070	/			
0.100	+/-0.010	-099	/			
Ø0.201 x 0.100	+/-0.010	-201x.099	/			
0.182	+/-0.010	-181	/			
5.32	+/-0.030	5.320	/			
5.036	+/-0.010	5.035	/		HG	
2.120	+/-0.010	2.120	/		VERU	
1.290	+/-0.010	1.290	/			
0.365	+/-0.010	-365	/			
0.218	+/-0.010	-214	/			
1.030	+/-0.010	1.030	/			
1.90	+/-0.030	1.890	/			
1.012	+/-0.010	1.011	/			
Ø0.201 x 0.100	+/-0.010	-201x-100	/			
0.786	+/-0.010	-784	/			
Ø0.392	+0.002/-0.000	-3925	/		mic	SL-4
R0.19	+/-0.030	R.188	/			
3.954	+/-0.010	3.953	/		HG	
0.162	+/-0.010	-160	/		VERU	
R0.19	+/-0.030	R.188	/			
R0.25	+/-0.030	R.250	/			
4.26	+/-0.030	4.262	/		HG	
2.800	+/-0.030	2.810	/			
Calculated dimension	+/-0.030	2.810	/			
0.162	+/-0.010	-161	/			
0.615	+/-0.010	-615	/			
0.435	+/-0.010	-432	/			
0.200	+/-0.010	-203	/			
0.381	+/-0.010	-380	/			
0.032	+/-0.010	-029	/			

Measured by:	14	Audited by:	14	Preliminary Approval:	N/A
Date:	16-10-8	Date:	16/10/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	
E	08.01.16	Dimensions revised	KJ/EC/DD	
F	10.09.23	Dimensions revised	KJ	

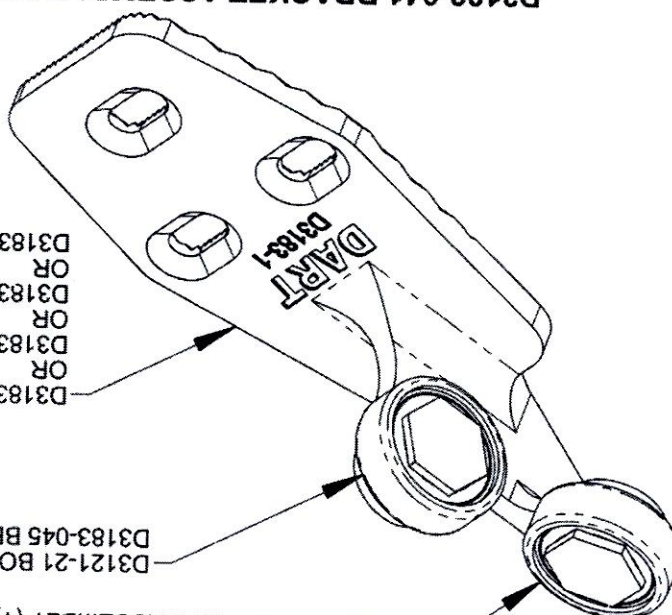


- D3183-7 WASHER**



- D3183-5 BEARING:**
SPECIFICATION CONTROL DRAWING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



D3183-1 BRACKET FOR -041 (SHOWN)
OR
D3183-2 BRACKET FOR -042 (OPPOSITE)
OR
D3183-3 BRACKET FOR -043 (SIMILAR)
OR
D3183-4 BRACKET FOR -044 (SIMILAR)

D3121-21 BOLT (1)
D3183-045 BEARING ASSEMBLY (1)

D3121-21 BOLT (1)
D3183-045 BEARING ASSEMBLY (1)

DESIGN		CHECKED		DATE	04.02.17	TITLE	BRACKET ASSEMBLY	SCALE	1:1
DRAWN BY		APPROVED		DRAWING NO.	D3183	REV. C	SHEET 1 OF 4		
DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA							

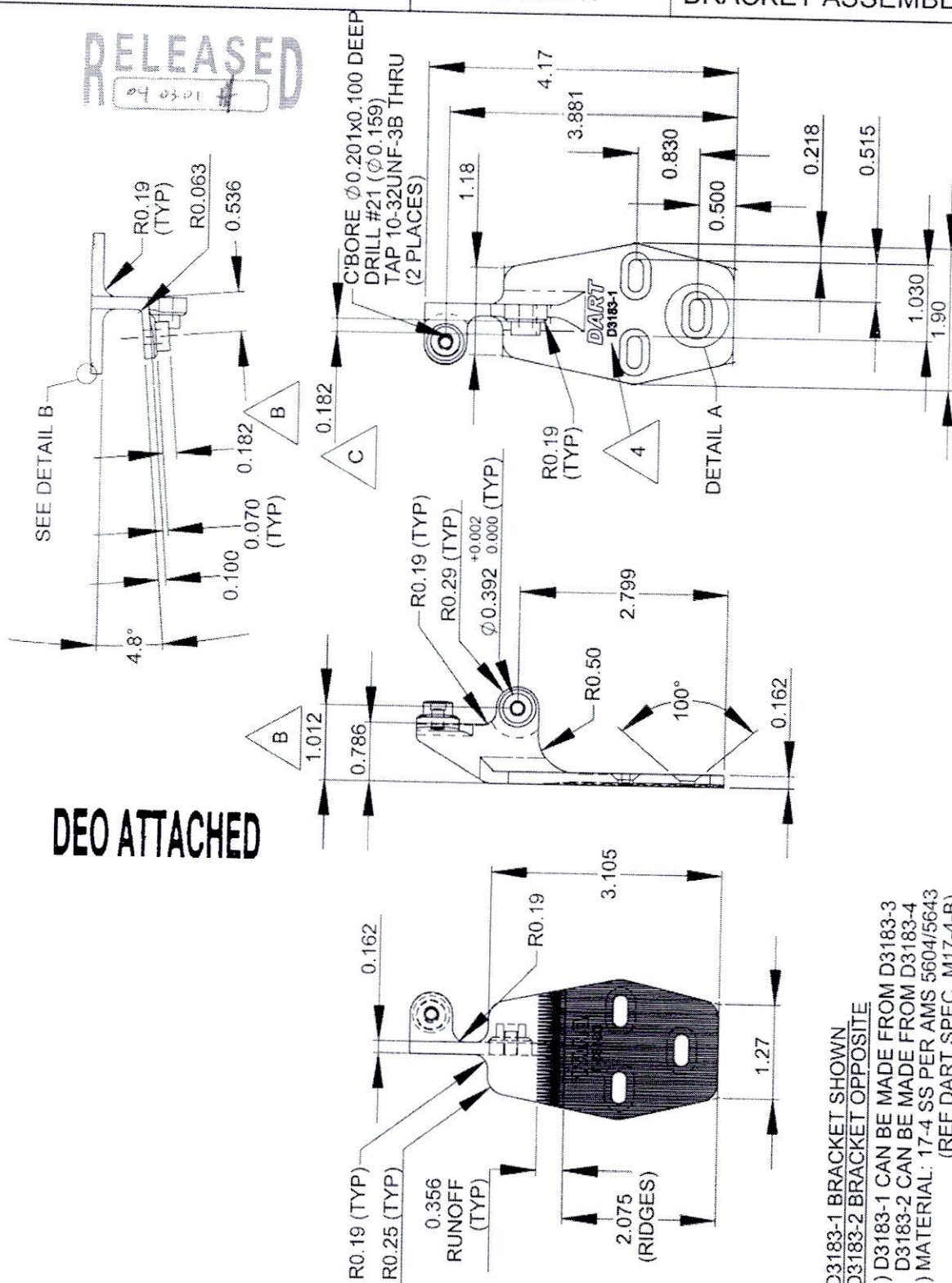
**DART**

04 03 01



DESIGN #	DRAWN BY OP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 2 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
04 03 01



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

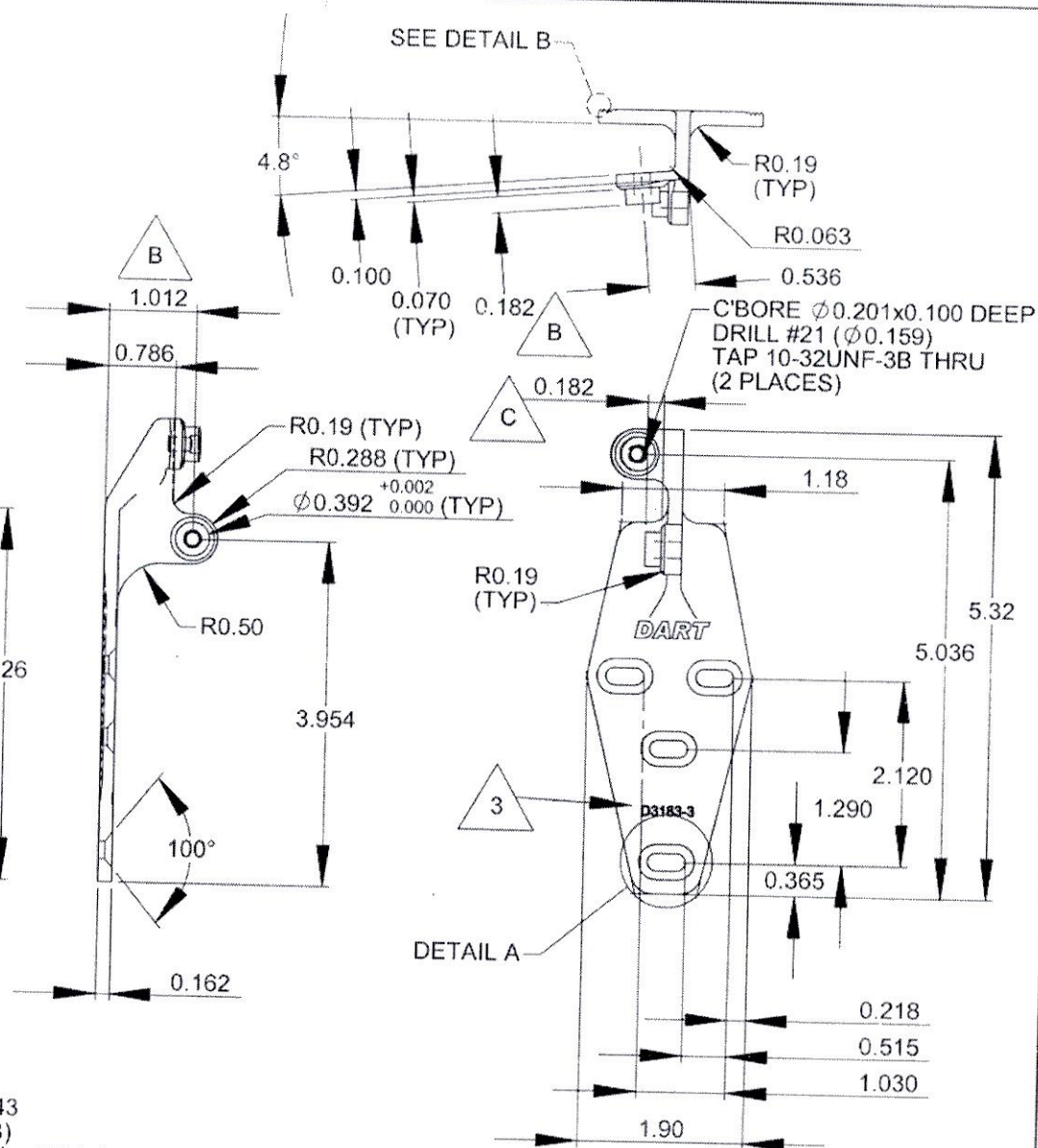
- 1) D3183-1 CAN BE MADE FROM D3183-3
- D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART PIN & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE		DRAWING NO.	REV. C
04.02.17		D3183	SHEET 3 OF 4
		TITLE	SCALE
		BRACKET ASSEMBLY	1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

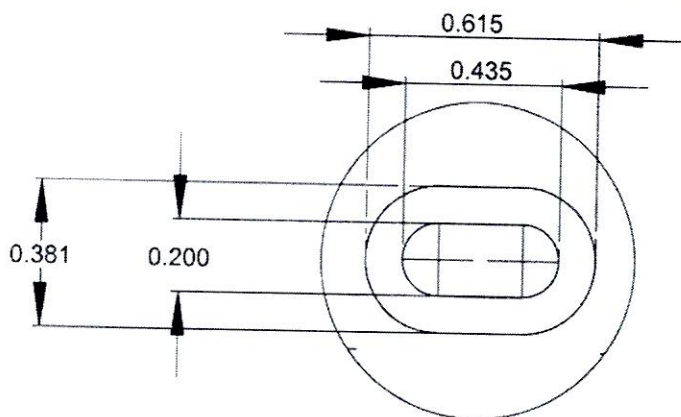
DEO ATTACHED
RELEASED

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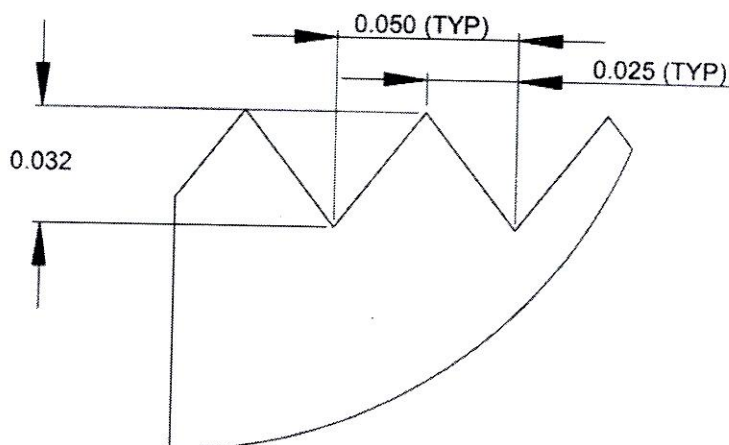
DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1



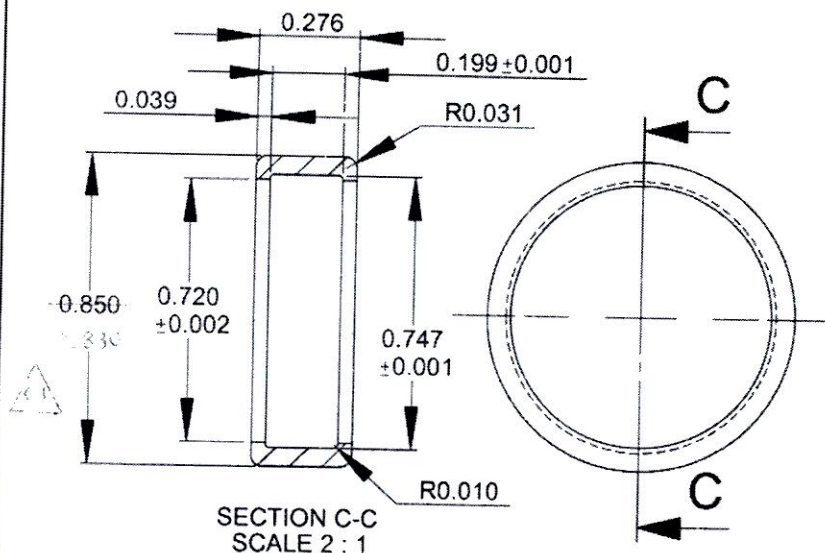
DETAIL A (2 : 1)

RELEASED
04 03 01

DEO ATTACHED



DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>1</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30		DATE 10/06/30		

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

RELEASED
2010-07-22
MP

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